Monday, 16/10/2006 9:24:29 AM Linda Lacelle User **Process Sheet** : LUG **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer : 28972 Job Number **Estimate Number Part Number** : D2725 P.O. Number S.O. No. : NA · D2725 REV C : 16/10/2006 **Drawing Number** This Issue Project Number : N/A Prsht Rev. : SMALL /MED FAB **Drawing Revision** Type First Issue Alk: : 28972 Material Previous Run Each : 20/10/2006 20 Um: Due Date Qty: Written By Checked & Approved By 99.02.11 Added 4 per Blank D Comment : Est. Est Rev:E Now on Waterjet 06-10-15 JLM **Additional Product** Job Number: Description: Machine Or Operation: Seq. #: M6061T6B0187X04000 6061-T6 Bar .178" x 4.0" 1.0 Comment: Qtv.: 0.1815 f(s)/Unit Total: 3.6309 f(s) =8001 T6 Bar 478" x 4.8" Material:6061-T6 (QQ-A-250/11) 4" x 0.188" Thick Note: I Blank makes 4 Batch: M/9 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE WATER JET FLOW WATER JET **)**.0 Comment: FLOW WATER JET 1-Cut as per Dwg D2725 Dwg Rev: Prog Rev: C 2-Deburr if necessary 4.0 QC8 Comment: SECOND CHECK



Page 1



Date: User:

Monday, 16/10/2006 9:24:29 AM

, Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 28972

Part Number: D2725

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:_

5756

FINAL INSPECTION/W/O RELEASE



6.0 QC21

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



N 26.10.24

Friday, 10/13/2006 9:30:50 AM

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number** : 28972

: 11704

P.O. Number

: 10/13/2006

This Issue

: NC Prsht Rev.

First Issue : //

Previous Run

Written By

Comment

Checked & Approved By

: Est. D

S.O. No. :

: MACHINED PARTS

Type

Added 4 per Blank

Part Number

Drawing Name

: D2725 : D2725 REV C **Drawing Number**

: N/A Project Number ; C **Drawing Revision**

Material

Due Date : 10/20/2006

: LUG

Qty:

20 Um:

Each

Additional Product





Machine Or Operation: Seq. #: 1.0

M6061T6B0187X04000



3.6309 f(s) Comment: Qty.: 0.1815 f(s)/Unit Total:

6061-T6 Bar .178" x 4.0"

Material:6061-T6 (QQ-A-250/11) 4" x 0.188" Thick

Note: I Blank makes 4 Batch:

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks: 8.3" -0.000"/+0.030"

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1

Description:

6061-T6 Bar .178" x 4.0"



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio D2725 Tumble to remove rough edges Deburr any rough edges after tumbling

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK





Dart Aerospace Ltd

W/O:			WORK ORDER C	HANGES			•	
DATE	STEP	PROCEDURE	CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
<u>.</u>								
Part No	:	PAR #: Fault	Category:	NCR: Yes	No DQ	A:	Date:	
				QA: I	N/C Close	d:	_ Date: _	

NCR:		V	WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC		Corrective Action Section B			Verification	A 1	
DATE	STEP	STEP Section A Initia		Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	
							,		

NOTE: Date & initial all entries

Date:

Friday, 10/13/2006 9:30:50 AM

Ùser: Kim Johnston **Process Sheet**

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 28972

Part Number: D2725

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location:

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



υaπ Ae	rospace Li	td							
W/O:			W	ORK ORDER CHANGES	3				
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:				Date:	
NOD.		,	WORK ORD	ER NON-CONFORMAN			u	Date:	
NCR:						·/			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section B Action Description Chief Eng	Sign & Date		erification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	28972
Description: Step Mounting Plate	Part Number:	D2725
Inspection Dwg: D2725 Rev: C		Page 1 of 1

	FIR	ST ARTICLE	INSPEC	TION CH	ECKLIST		
		X First Ar	ticle	Prof	totype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method o		omments
Ø0.257	+0.005/-0.000	0.257	i/		vern		
R0.386	+/-0.010	RO.386			RADIUS (nage	
R0.125	+/-0.010	RO.125			RADIUS (JUASE	
3.080	+/-0.005	3.080	/		verN	0	
			<u>.</u>				
<u> </u>		,					
Measured by:	MI.M	Audited by:)	Prototype /	Approval:	N/A
Date:	OB 10 17	Date:		19		Date:	N/A
Rev Date	Change			•		Revised b	y Approvéd

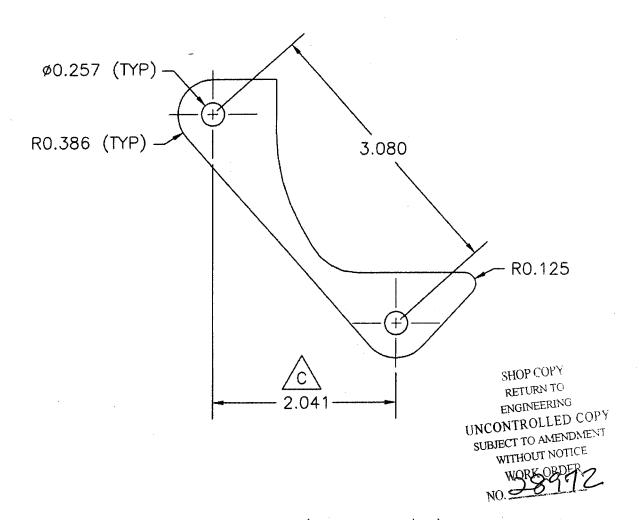
Rev	Date	Change	Revised by	Approve	∌d
Α	04.05.06	New Issue	KJ/JLM O	\JJ]	





DES	IGN KE	DRAWN BY	DART AEROSPACE USA, INC.
CHE	CKEQ	APRINOVED	DRAWING NO. REV. C
	M	1 75	D2725 SHEET 1 OF
DAT	Ε		TITLE SCALE
98	3.10.19		STEP MOUNTING PLATE 1:
Α		97.12.04	NEW ISSUE
В		98.05.04	0.188 THICK WAS 0.125
С		98.10.19	REVISED GEOMETRY FOR 5.5° STEP ANG.

RELEASED



MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.188 THICK TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED